

Date: Wednesday, 06/08/2008 2:06:47 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 41029			Part Number	: D28105	
Estimate Number	: 11044			Drawing Number	: D2810 / D2727	
P.O. Number	:			Project Number	: N/A	
This Issue	: 06/08/2008		S.O. No. :	Drawing Revision	: C / A1	
Prsh Rev.	: NC			Material	:	
First Issue	: / /		Type :	MACHINED PARTS	Due Date	: 20/08/2008
Previous Run	: 40900			Qty:	10	Um: Each
Written By	:					
Checked & Approved By	: <u>DUO 08-8-06</u>					
Comment	: Est. A 04.11.30 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 2.1000 f(s)/Unit Total : 21.0000 f(s) 304 RD Tube .500 x .035W Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 Batch: <u>M107403</u> ⑥ <u>M108250</u> <u>SR 08/08/20</u> ⑩	
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 2-Deburr <u>Q/H/</u> <u>08/08/26</u> ⑩ <u>SR 08/08/20</u> ⑩	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP <u>08/08/27</u> ⑩	
4.0	POWDER COATING	POWDER COATING	
		<u>M102316</u> <u>08/08/27</u> ⑩	
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 START TIME: <u>3:20</u> OVEN TEMPERATURE: <u>320° F</u> FINISH TIME: <u>3:30</u> <u>M-1</u> <u>08/08/27</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:06:48 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 41029

Part Number: D28105

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



jl

08-08-27

X17

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 265*

AS

08/08/28 *10*

16

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



AS 08/08/29

MF 08-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

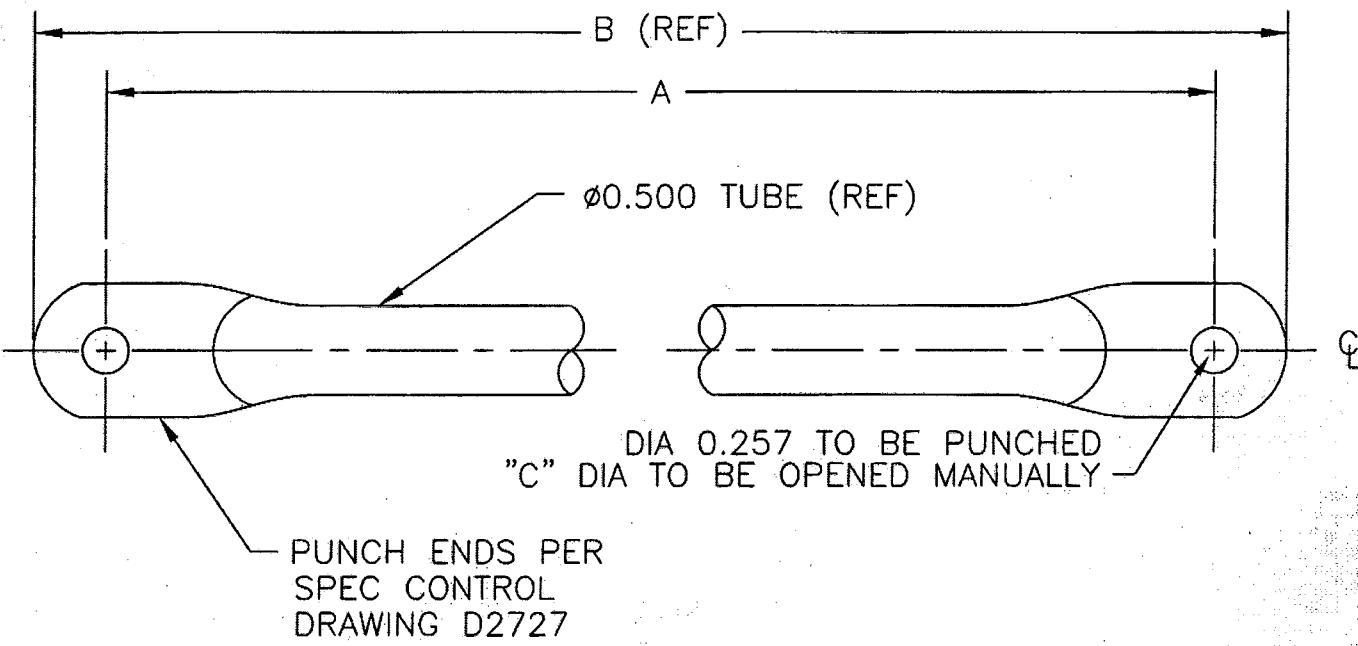
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	APPROVED	DRAWING NO. D2810	
CHECKED	APPROVED	REV. C SHEET 1 OF 1	
DATE 04.11.22		TITLE STRUT	
		SCALE NTS	
A 00.11.08 NEW ISSUE			
B 03.09.11 ADD FINISH			
C 04.11.22 ADD -5			

RELEASED

05.03.11



PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5	23.01	23.81	0.266

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WITHOUT NOTICE

WORK ORDER

NO. 41021

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.500 x 0.035 WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

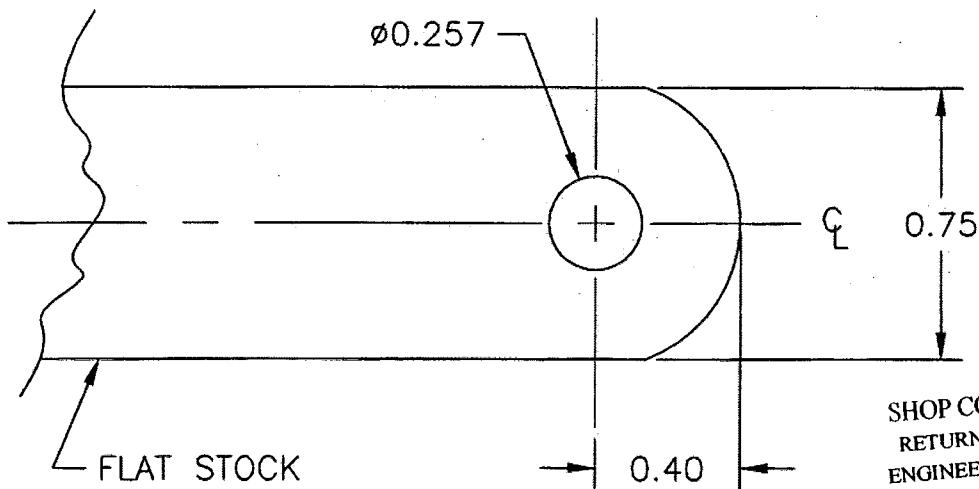
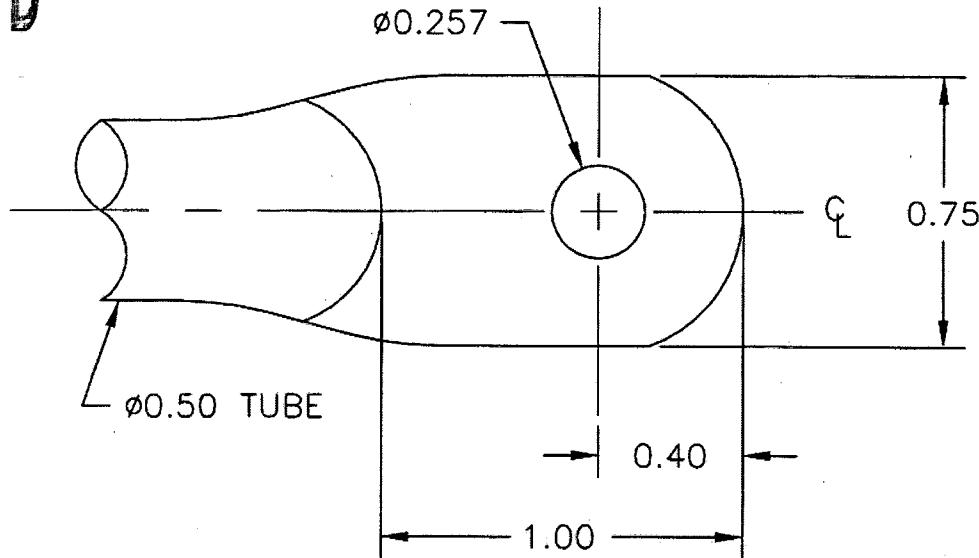
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DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DMY</i>	APPROVED <i>CF</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	HCP 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE

NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER
NO. 11029